

Work Order ID 83416

83416

Page 1

April-18-12 8:09:55 AM

Item ID: D2939-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle LH In. 206

Stop *NS2*

Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2939	Rev C								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per								
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120		0.00							
120	QC1 - Inspect dimensions to dimension sheet								
QC	QC2	0.00							
Quality Control	Memo								

RT 12-05-26

RT 12-05-26

RT 12-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83416

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Page 2

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Start Date: 18/04/2012 Start Qty: 6.00

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

SL 12-05-28

130

QC Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish Memo

0.00

Hand Finishing

6 125-30

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat Memo

0.00

Powder Coating

START TIME: 8:50 OVEN TEMPERATURE:
FINISH TIME: 9:20

6x 12/5/31

W121134

3200F

9:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83416

April-18-12 8:09:55 AM

83416

Page 3

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle LH In, 206

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Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <i>425</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

*E 0 125-81**440/31 E**12/04/12**mk**12-06-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-18-12 8:09:59 AM

Page 1

Work Order ID: 83416

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206

83416

D2939-1

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	57.0000	1	6			

D6101-001

Saddle Billet

B 83309 x 6

**

12-05-26

Location	Loc Qty	Loc Code
MAT040	3	
69677	2	
76836	1	
MAT041	54	
80764	4	
81923	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	834/6
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.121	.121	.121		
B	0.100	0.140		.115	.117	.121	.117		
C	0.100	0.140		.116	.117	.114	.116		
D	0.210	0.230		.220	.222	.221	.222		
E	1.245	1.255		1.248	1.250	1.252	1.252		
F	1.245	1.255		1.248	1.250	1.251	1.252		
G	2.495	2.505		2.500	2.501	2.502	2.5		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.578	1.579	1.578	1.577		
J	2.495	2.505		2.500	2.500	2.501	2.502		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.115	.116	.114	.116		
O	0.540	0.560		.550	.551	.548	.548		
P	0.490	0.510		.501	.501	.503	.500		
Q	3.715	3.725		3.720	3.718	3.720	3.719		
R	2.720	2.760		2.740	2.741	2.740	2.740		
S	0.240	0.270		.252	.248	.247	.248		
T	0.100	0.180		.136	.134	.138	.133		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.368	1.368	1.368		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270	/	1.2606	1.263	1.262	1.267		
Y	1.565	1.585	DT8695 A/B	1.575	1.577	1.575	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RT
Date:	12-05-26

Audited by:	X
Date:	12-05-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

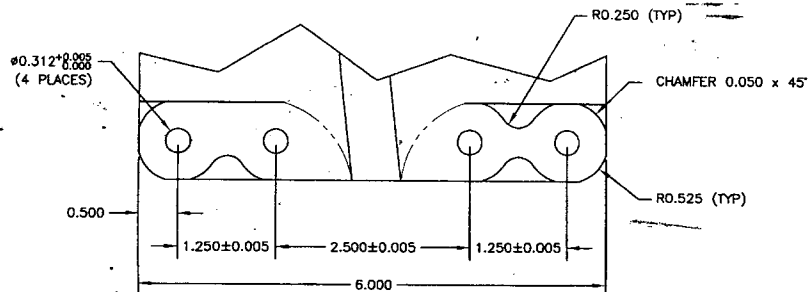
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

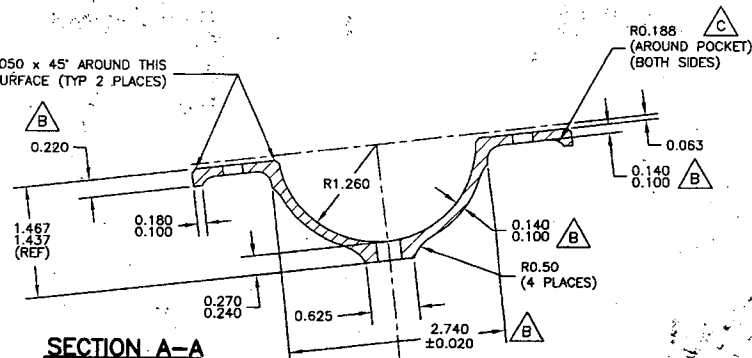
NOTE: Date & initial all entries



VIEW C-C

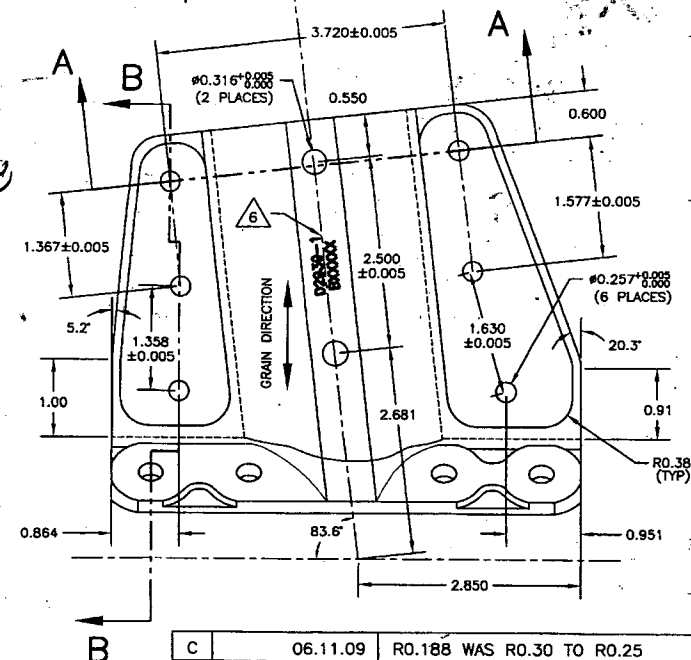
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 83416 MLJ
 12/04/18



SECTION B-B

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

01.0012

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C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SCALE
06.11.09	SADDLE INSIDE	2:3

REV. C
 SHEET 1 OF 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 83916
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5A	6A	7A	8A	By	Date
A	0.100	0.140		.123	.123				
B	0.100	0.140		.117	.123				
C	0.100	0.140		.121	.118				
D	0.210	0.230		.223	.222				
E	1.245	1.255		1.251	1.251				
F	1.245	1.255		1.252	1.25				
G	2.495	2.505		2.5	2.502				
H	0.510	0.515		.513	.513				
I	1.572	1.582		1.578	1.58				
J	2.495	2.505		2.501	2.501				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.116	.115				
O	0.540	0.560		.549	.551				
P	0.490	0.510		.501	.503				
Q	3.715	3.725		3.718	3.72				
R	2.720	2.760		2.740	2.74				
S	0.240	0.270		.246	.251				
T	0.100	0.180		.138	.134				
U	1.625	1.635		1.63	1.63				
V	1.362	1.372		1.364	1.364				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.263	1.259				
Y	1.565	1.585	DT8695 A/B	1.578	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RT H
Date:	12-05-26

Audited by:	L
Date:	12-05-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	